

Spsh

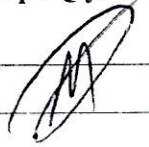
Work Order ID 157091-2

157091

Page 1

Monday, February 13, 2017 11:46:51 AM

Item ID: D5359-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Strut Assembly, LH/RH
Start Date: 2/21/2017 Start Qty: ~~2.00~~ *3* Cust Item ID:
Required Date: 2/21/2017 Req'd Qty: 3.00 *3* Customer:
Reference:

Approvals: Process Plan:  Date: FEB 13 2017 Tooling: Date:
QC: Date: SPC (Y/N): Date:
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5359	B

110 0.00

110

Small Fab

Memo

Small Fab

1- CUT SQUARE TUBING AT 48.00"

3

FF

FEB 14 2017

P10

112

0.00

112

CNC Bend 1

Memo

0.01

CNC Delta 100 Bender

1- FORM TUBING AS PER DWG USING DT10300

DAS
10
9-89

using CNC Bender 100
And Falio 32
Bend prog D5359

0.00

③ DP 17-2-15

114

114

Small Fab

Memo

0.01

Small Fab

1- TRIM OFF EXTRA MATERIAL USING DT10300

2- DEBURR

3

FF

FEB 15 2017

157091

Monday, February 13, 2017 11:46:51 AM

[illegible]

Work Order ID 157091

157091

Page 3

Monday, February 13, 2017 11:46:51 AM

Item ID: D5359-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly, LH/RH
 Start Date: 2/21/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 2/21/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							DAS 14 9-89
150						3	0		
QC	Memo	0.01							17/02/28
Quality Control									
160	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel	0.00							
160									
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 1:20 OVEN TEMPERATURE: 700 FINISH TIME: 1:50								3 0 17-02-28. DAS 34 9-89
170	QC3- Inspect Part Finish	0.00							DAS 36 9-89
170						3			
QC	Memo	0.01							
Quality Control									

FEB 28 2017

Work Order ID 157091

Monday, February 13, 2017 11:46:51 AM

157091

Page 4

Item ID: D5359-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Assembly, LH/RH

Start Date: 2/21/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/21/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00				2	FF		MAR 21 2017
180									
Small Fab	Memo	0.01							
Small Fab	1- ASSEMBLE INSERT IN TUBE AS PER DWG ***DO NOT INSTALL CLEVIS***								
190		0.00				2	φ		17-3-22 / D.A. FB 17-03-22
190									
Mill Conv	Memo	0.01							
Conventional Milling Machine	1- DRILL WITNESS HOLES TRUE BOTH WALLSW AS PER DWG, SHEET 2, DETAIL A AND VIEW B-B 2- DEBURR								
200	QC5- Inspect part completeness to step on W/O	0.00				2			17-3-22 / D.A. FB 17-03-22
200									
QC	Memo	0.01							
Quality Control									

MAR 24 2017

DAS
38
8-69

157091

Monday, February 13, 2017 11:46:51 AM

N900040100

Stop *NS2*

Start Date: 2/21/2017 **Start Qty:** 3.00 ***3***

Required Date: 2/21/2017 **Req'd Qty:** 3.00 ***3***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

210

210

Small Fab

Memo

0.01

ASSEMBLE CLEVIS AND NUT AS PER DWG

Small Fab

220

QC5- Inspect part completeness to step on W/O

0.00

220

QC

Memo

0.01

Quality Control

230

Identify as per dwg & Stock Location: St 370 0.00

0.00

230

Packaging

Memo

0.01

Packaging

DAS
38
MAR 27 2017

9-89 6 DAS

Monday, February 13, 2017 11:46:51 AM

Page 6

17/3/289

MAR 28 2017

Picklist Print

Page 1

Monday, February 13, 2017 11:47:11 AM

Work Order ID: 157091

157091

Parent Item: D5359-041

D5359-041

Parent Item Name: Strut Assembly, LH/RH

Start Date: 2/21/2017

Required Date: 2/21/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A RQ 16.03.23 Verified by: DD
17.01.20 AS PER REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6		Manufactured	No				Each	15.0000		6	DAS 30 9-89		
D2690-6									**			MAR 2 1 2017	
Lanyard													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST009	15								
				155325	15								
M304TR0.750W.049		Purchased	No				f	181.1371		10.52621			
M304TR0 750W 049									**			FEB 14 2017	
304 RD Tube .750 x .049W													
M 304 TSC. 750W. 049				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA002	181.1370741								
				M134528	30.2105266								
				M134824	4.8478935								
				M135093	1.905367								
				M135242	14.0073785								
				M135373	16.44849								
				M135709	0.0790537								
				M135857	0.0003668								
				M136323	0.045893								
				M136667	13.592105								
				M136760	100								
D5359-3		Manufactured	No				Each	2.0000		6	DAS 30 9-89		
D5359-3									**				
Insert				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				prelim	2								
				156007	2								

Picklist Print

Page 2

Monday, February 13, 2017 11:47:11 AM

Work Order ID: 157091

157091

Parent Item: D5359-041

D5359-041

Parent Item Name: Strut Assembly, LH/RH

Start Date: 2/21/2017

Required Date: 2/21/2017

Start Qty: 3.00

Required Qty: 3.00

D5359-5 Manufactured No

Each 2.0000

3

30
9-89

MAR 21 2017

D5359-5

Clevis, Aircraft End

Location

Loc Qty

Loc Code

prelim

2

156008

2

Each

3.0000

3

30
9-89

D5359-7 Manufactured No

D5359-7

Clevis, Basket End

Location

Loc Qty

Loc Code

ST165

3

156009

3

Each

2.0000

6

DAS
30
9-89

AN3CH11A Purchased No

AN3CH11A

Bolt (Drilled Head)

Location

Loc Qty

Loc Code

GA

2

m136685

2

Each

8.0000

6

DAS
30
9-89

AN3CH12A Purchased No

AN3CH12A

Bolt (Drilled Head)

Location

Loc Qty

Loc Code

GA

8

m136685

8

6

MAR 21 2017

Picklist Print

Monday, February 13, 2017 11:47:11 AM

Work Order ID: 157091

Parent Item: D5359-041

Parent Item Name: Strut Assembly, LH/RH

157091

D5359-041

Start Date: 2/21/2017

Required Date: 2/21/2017

Start Qty: 3.00

Required Qty: 3.00

MS17984-C405

Purchased

No

Each

5.0000

3

DAS

30

9-89

MAR 21 2017

MS17984-C405

Pin, Quick Release

**

Location

Loc Qty

Loc Code

over005

3

157167

③

153302

3

ST315

2

146282

2

Each

1.0000

3

**

DAS

30

9-89

MS17984-C608

Purchased

No

MS17984-C608

Pin, Quick Release

Location

Loc Qty

Loc Code

ST314

1

1137099

②

M136717

1

Each

1,004.000

12

**

DAS

30

9-89

MAR 21 2017

MS21043-3

Purchased

No

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

403

m130673

11

m136182

392

GA

393

m133990

27

m136295

366

ST302

59

m135864

59

ST304

69

m131340

69

M136702 ⑫

Picklist Print

Monday, February 13, 2017 11:47:11 AM

Work Order ID: 157091

157091

Parent Item: D5359-041

D5359-041

Parent Item Name: Strut Assembly, LH/RH

Start Date: 2/21/2017

Required Date: 2/21/2017

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0363R

Purchased

No

Each

217.0000

30

DAS

NAS1149C0363R

30
9-89

MAR 21 2017

Washer

Location

Loc Qty

Loc Code

FP001

129

m133077

129

GA

79

m133077

79

30

ST266

9

m133077

9

NAS509-6C

Purchased

No

Each

25.0000

6

DAS

NAS509-6C

30
9-89

MAR 21 2017

Nut

Location

Loc Qty

Loc Code

ST551

25

M128110

3

M128429

10

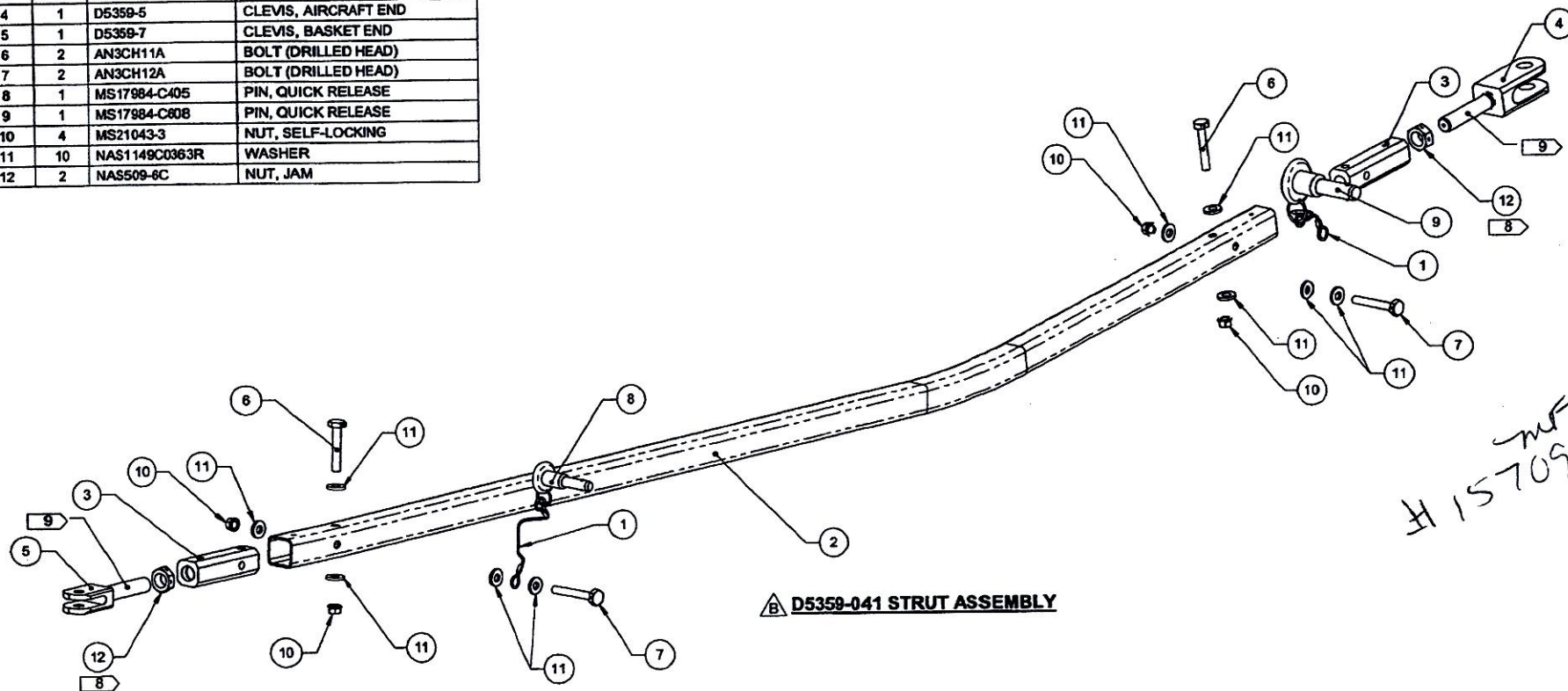
M129913

12

3

3

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5359-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5359-1	STRUT
3	2	D5359-3	INSERT
4	1	D5359-5	CLEVIS, AIRCRAFT END
5	1	D5359-7	CLEVIS, BASKET END
6	2	AN3CH11A	BOLT (DRILLED HEAD)
7	2	AN3CH12A	BOLT (DRILLED HEAD)
8	1	MS17984-C405	PIN, QUICK RELEASE
9	1	MS17984-C808	PIN, QUICK RELEASE
10	4	MS21043-3	NUT, SELF-LOCKING
11	10	NAS1149C0363R	WASHER
12	2	NAS509-6C	NUT, JAM



△ D5359-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.48 lbs
- 8) HAND TIGHTEN NAS509-6C NUT
- 9) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

B	REDESIGNED TO BE COMPATIBLE WITH BOTH LH + RH INSTALLATIONS. -042 DELETED.	AJS	16.12.12
A	NEW ISSUE	VS	15.11.23
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5359	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	16.12.12	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-02-10
EW17-508
522 en

APPROVED

D5359-7 CLEVIS, BASKET END

A

AN3CH12A BOLT
NAS1149C0363R WASHER (3)
MS21043-3 NUT, SELF-LOCKING

D2690-6 LANYARD ASSEMBLY

MS17984-C405 PIN, QUICK RELEASE

D5359-5 CLEVIS, AIRCRAFT END

D2690-6 LANYARD ASSEMBLY

MS17984-C608 PIN, QUICK RELEASE

AN3CH12A BOLT
NAS1149C0363R WASHER (3)
MS21043-3 NUT, SELF-LOCKING

C

AN3CH11A BOLT
NAS1149C0363R WASHER (2)
MS21043-3 NUT, SELF-LOCKING

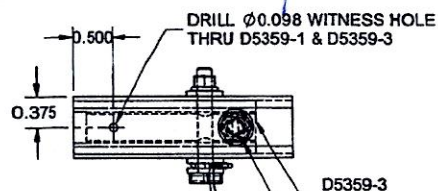
D5359-1 STRUT

NAS509-6C NUT, JAM

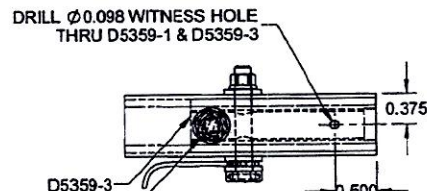
AN3CH11A BOLT
NAS1149C0363R WASHER (2)
MS21043-3 NUT, SELF-LOCKING

NAS509-6C NUT, JAM

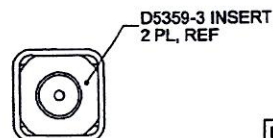
D5359-041 STRUT ASSEMBLY



DETAIL A
SCALE 2X



VIEW B-B
SCALE 2X
ROTATED 11° CW

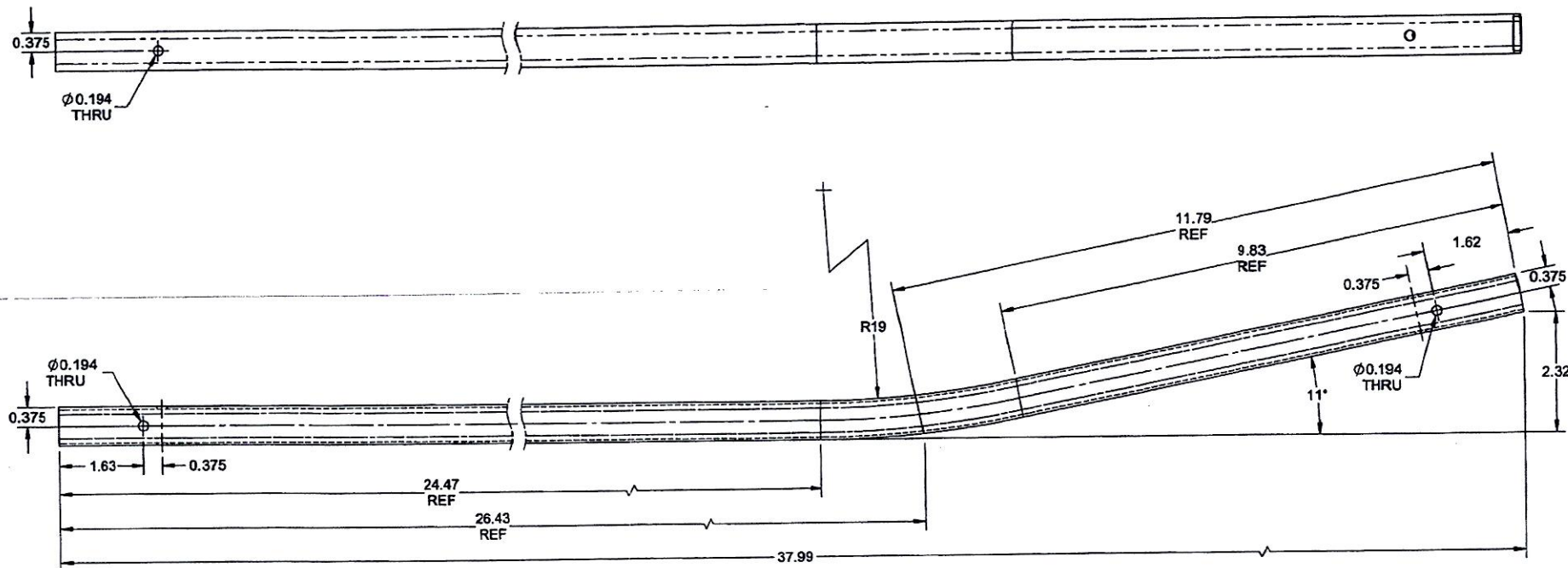


SECTION C-C
SCALE 3X

RELEASED
2017-02-10

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO. D5359	REV. B
MFG. APPR.	DD	SHEET 2 OF 4	
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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D5359-1 STRUT

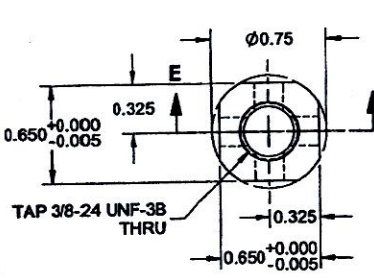
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC M304TS0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.40 lbs
- 8) FLAT LENGTH 38.21 REF

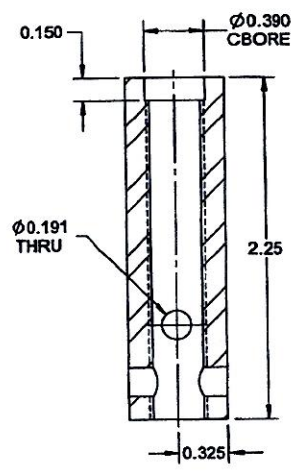
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2017-02-10

APPROVED

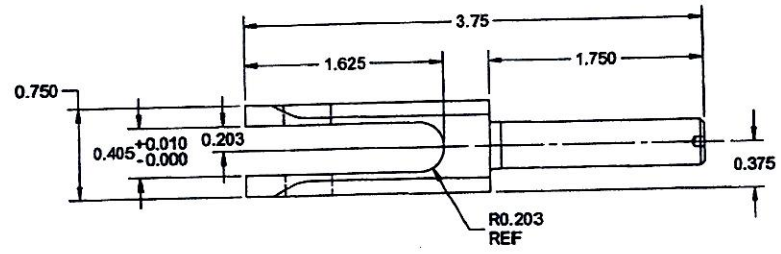
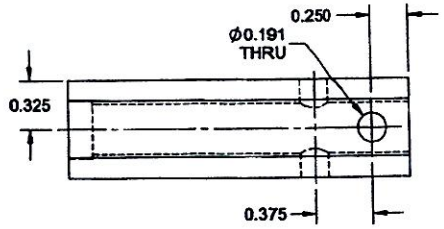
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CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5359	SHEET 3 OF 4
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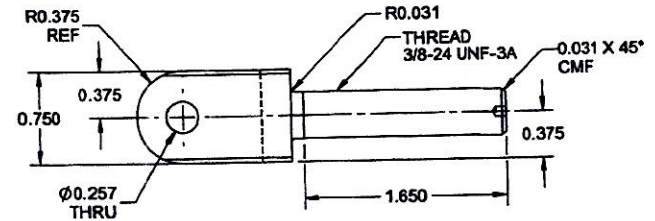
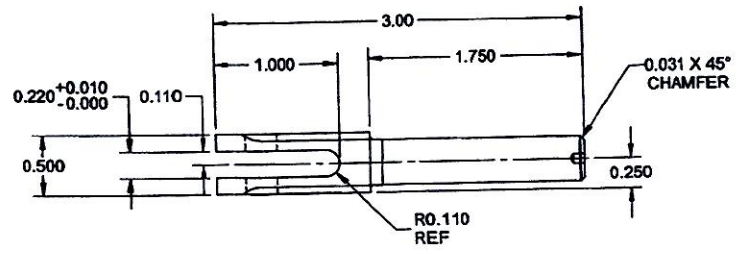
D5359-3 INSERT



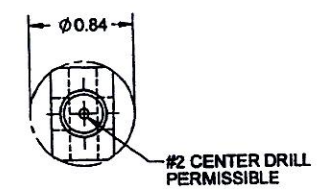
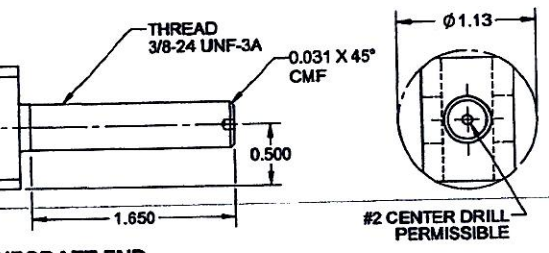
SECTION E-E



D5359-5 CLEVIS, AIRCRAFT END



D5359-7 CLEVIS, BASKET END



- NOTES:**
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
OR: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT -3: 0.19 lbs
-5: 0.27 lbs
-7: 0.13 lbs

RELEASED
2017-02-10

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5359	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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